Work Orde November-15-12	er ID 93268 10:42:46 AM			*932	268*							Page 1
Item ID: Revision ID:	D350-567-031			Accept	*N900	0040	100	ገ*	Setup		1 71	S1*
Item Name:	Interior Floor Window (S	Sliding Door Co	ompatible)							Stop	*N:	S2*
Start Date: Required Date: Reference:	_	ety: 1.00 Qty: 1.00	*1* 6	>	Cust Item Customer:							
Approvals:	Process Plan:	165	Date: 12-1/-1	Tooling:	D	ate:			Run	Start	7	R1*
	QC:		Date:			Pate:				Stop	*N	R2*
Sequence ID/ Work Center II	Operati Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	•										
N/A	Rev D		₽ B									
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	DOCUME	Memo Photocopy blu	Olozaf	0.00 0.00 er PPP D350-567-031 ch	17/12/7/			_csL	E PE	Blr	12/12	121
110				0.00								
110 Packaging Packaging	Packaging	Memo Pick Packing	Kit	0.00 PICKE	VT			2				12/12/210
•		***ENSURE	DT 8439 TEMPLATE IS	S INCLUDED***								
*120	QC4-100	% Inspect kits fo	r completeness	0.00 AS	(. []							
QC Quality Control		Memo		0.00	15/12/12							

32	~~~~ *	

												DQA:	:Date	•
NCR:	Yes	/ No					WORK ORDER NON-C		NFOR	MANCE / UPI	DATE	•		*
							,			·		QA Closed:	Date:	
Vork Ord	er.						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
• O. K. O. C							Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part	No.						Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
							Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	No.						Work Order Update]		Large Fab	Composite	j	Supplier	
Root					Des	cri	otion of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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	•						F.	AUL	T CATE	GORY				
Land	ing (Gear					General	_				_	·	-
		Bending					Bend		Grain			Ovalized		Pressure/Forced
		Centre N	ot Conce	ntric to	O/S		BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks					Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped	=			Burrs		Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
		Cuffs				L	Contamination	L	Mainte	enance		Part Moved		
		Heat Trea	at			L	Countersink	L	Mislabe	eled		Positioned V	Vrong	-
		Inspectio	n Strip in	Tube		L	Cut Too Short		Misread			Power Loss/	Surge	Other
	L	Ripples in	n Bend				Drill Holes	Offset						
		Torque W	Vaves in E	Extrusio	n		Drawing	Out of Calibration						
		Turning S	equence				Finish		Out of Sequence					

Wave/Twist in Tube

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0.00

0.00

Identify and pack for shipping as per PPP D350-567-031

Location: PPP Rev:

Memo

QC21- Final Inspection - Work Order Release

Packaging

140

Quality Control

140

CK 12/12/21
MF
12-12-21

Insp.

Stamp

Page 2

NCR:	Voc	1	No
NCK:	Yes	/	INO

											DQA:	Date:	61
NCR:	Yes	/ No					WORK ORDER NON-C	O	NFORM	MANCE / UPDATE			
											QA Closed:	Date:	
Vork Ord	er:						DISPOSITION			AGAINST D	EPARTMENT	/PROCESS	
Part NCR	Vo.						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	— 1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Desci	-	tion of work order update	i	nitial	Action	Sign &		·
Cause	,	Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining													
							F/	AUL	T CATE	GORY	·		
Land	ng (Gear Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t 1 Strip in Bend	Tube			General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/Unclear enance	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	oct sissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Turning Se	equence				Finish		Out of 9	Sequence			

Wave/Twist in Tube

79478

83542

90297

91696

No

Manufactured

Manufactured

ST210 No

Location

Loc Qty Loc Code 9 120 14.0000

Each

0.43737

500

92.66891

120

Each

9.0000

91696

Loc Qty Loc Code Location ST211 14 79310 1 91755 13

Doubler

Bracket

Page 1

Status

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	O	VFOR	MANCE / UP	DATE	•		
												QA Closed:	Date:	
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part							Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor	Engineering Quality
NCR	No.						Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Desc	crip	otion of work order update		nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		O	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator faterial etup ther rocess upplier raining napproved														
Land							General F	AUL	T CATE	GORY			· · · · · · · · · · · · · · · · · · ·	
cond		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	Crimped it n Strip in		O/S		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		1	on Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	\vdash	Torque W		xtrusio	n		Drawing		ł	Calibration				
		Turning S			Ì		Finish	Out of Sequence						

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print November-15-12 10										Page 2
Work Order ID:	93268									3
Parent Item:	D350-567-031						Start	Date: 11/15/12	Required Date: 1	2/07/12
Parent Item Name:	Interior Floor Window (Sliding Door	Compatil	ble)				Star	t Qty: 1.00	Required Qty: 1	.00
D3212-0 Liloor Window	Manufactured	No			120	Each	3.0000	9018	+2- 6-7B	P
7-			Locatio	<u>n</u>	Loc Oty		Loc Code		•	
			ST210		3					
· <u>~</u>				81496	3					
Door Assembly	Manufactured	No			120	Each	1.0000	\$28	37 JB	pl
			Locatio	<u>n</u>	Loc Qty		Loc Code		•	•
			ST211		1					
				90815	1				_	
DI3439 template	Manufactured	No			120	Each	0.0000		12/13	pl
NS20470AD45 Rivet, Universal Head	Purchased	No			120	Each	1,332.0000	40	40 80 JB	Pl
			Locatio	<u>n</u>	Loc Qty		Loc Code		V	·
			334		1282					
				122452	1282			1224	<u>5</u> 2	
			ST336		50					
40				120142	50					
MIS20470AD4-6 Rivet, Universal Head	Purchased	No			120	Each	4,241.0000	90	98 180 - JB	12/12/2
			Locatio	<u>n</u>	Loc Qty		Loc Code		•	
			ST336		4241				_	
				117395	16					
				118927	143				_ '[
				119109	12				- . '	
				120142 121524	81 65				<u> </u>	
				121324	924				_	
				123021	3000			12368	<u> </u>	

											DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDATE		•			
											QA Closed:	Date:		
Morle Ord	05:					DISPOSITION			AGAINS	T DEF	PARTMENT/	PROCESS		
Nork Ord	er:					Rework	٦		Skid-tube Crosstub	□۵		Water Jet	Engineering	
Part I	VΩ					Scrap	1		Machining Small Fa		Proc	d. Eng. Coor.	Quality	
	•••					Use-as-is	1		noforming Finishin			e/Packaging	Other	
NCR I	No.					Work Order Update	1		Large Fab Composit	~ 	·	Supplier	1 1	
Root					1	iption of work order update		nitial	Action		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
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perator	_													
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etup	<u> </u>													
ther rocess	-				:	•								
upplier	-													
raining										i				
napproved														
			L		L	F	AUL	T CATE	GORY					
Landi	ng (Gear				General								
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
	L	Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct	Weld	
		Crushed/0	Crimped.		<u> </u>	Burrs	\perp	4	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled	
	_	Cuffs			<u> </u>	Contamination		Mainte	enance	<u> </u>	Part Moved			
		Heat Trea				Countersink	_	Mislabe			Positioned V		7	
	<u> </u>	Inspection		Tube		Cut Too Short	_	Misread	d	<u></u>	Power Loss/	Surge	Other	
	<u> </u>	Ripples in			L	Drill Holes	Offset							
	\vdash	Torque W			n	Drawing	Out of Calibration							
	\vdash	Turning Se	•		ļ	Finish		1	Sequence					
	1	Wave/Twi	ist in Tub	oe -	1	Folio		Outside Dimensions						

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Λ	Picklist Print November-15-12 10											Page 3
Ţ	Work Order ID:	93268										3
F	Parent Item:	D350-567-031							Start	Date: 11/15/12	Required Date: 1	2/07/12
F	Parent Item Name:	Interior Floor Window (Sliding Door Co	ompatib	le)				Star	t Qty: 1.00	Required Qty: 1	.00
R	MS20470AD4-9 Rivet, Universal Head	P	urchased	- No			120	Each	6,136.0000	20	28 40 /	
)A "					Location		Loc Qty		Loc Code			
					ST336		6136				<u> </u>	
					1	16081	117					
					1	18614	148					
					1	20769	52				_	
						21415	124			1200	~ ~	
						22452	695			1224	<u> </u>	
					1	23525	5000				_	,
	MS21042L06 Nut	P	urchased	No			120	Each	331.0000	1203	73	
Da	-/				Location		Loc Qty		Loc Code			
1	/				315		258					
/						22441	258			1220	<u> </u>	
/					ST317		73					
						.22151	73					
	NASIIMADN63211 Washer	P	urchased	No			120	Each	91.0000	8/2396	816 - JB	12/12/21
					Location		Loc Qty		Loc Code	12390	0 0	, .
					298		77				V	
						22441	77			12244	₽ ` ′	
					ST298		14				Bears.	
						18428	14			-		

											•	DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	VFOR	MANCE / UPE	DATE	QA Closed:	Date:	,
Vork Ord	er.						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part NCR	No.						Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Desc		tion of work order update	ł	nitial	Act		Sign &		
Cause	_	Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data uip/Tooling perator aterial etup ther ocess applier aining														
								AUL	T CATE	GORY				
Land		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped. nt n Strip in		O/S		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		1	on Incomplete ions Incomplete/U enance eled	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in					Drill Holes	L	Offset					
		Torque W Turning S			າ [Drawing Finish		1	Calibration Sequence		 		

Wave/Twist in Tube

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REFERENCE ONLY SMA

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5.0 **PARTS LIST**

Qty	Qty	Qty	Qty	Qty	Qty -117	Part Number	Description
-015	-017	-025	-027	-111	-117	Part Number	
X				1	l	D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	Х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		Х				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
,			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				Х		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					Х	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
<u> </u>				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT
I							(SLIDING DOOR COMPATABLE)

Qty	Qty	Qty	Qty	Qty		
-013	-023	-113	-115	-031	→Part Number	Description
Х					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		Х			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				Х	D350-567-031	INTERIOR FLOOR WINDOW KIT
l _						(SLIDING DOOR COMPATABLE)
					D2125	REPLACEMENT WINDOW, SMALL
11					D2942	REPLACEMENT WINDOW, LARGE
	1			<u> </u>	D3290-041	REPLACEMENT WINDOW, LARGE REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
		11			D3290-041	REPLACEMENT WINDOW ASSEMBLT, EXTINA BARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1		<u> </u>	D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12	-		2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21		<u> </u>	AN526C832R9	SCREW (OR AN526C832-9,OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ.	2 SQ.	2 SQ.		<u> </u>	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
YD.	YD	YD				
					-0076910450	*NEORRENE SEAL **
					=D2463-0450	DOUBLER
				G-	-D3210-1	BRACKET
			ļ	,	-D3211-1	_FLOOR WINDOW
					=D3212-1	
			 	<=====================================	-D3213-041	_DOOR ASSEMBLY DOUBLER
			1		D3293-1	BRACKET
			1	ļ	D3294-1	
	ļ		1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY NEOPRENE SEAL
			1		D2463-0530	
			9	<u>8</u>	-AN526C632R12-	-SCREW:(OR:AN526C632±12; OR:MS51957-32) -WASHER ➤
			9	<u>_8=</u>	FAN960JD6	
			9 4	==8==	-MS21042L06	
			2	~ 40=	=MS20470AD4-5=	
			115	=90 =	-MS20470AD4-6-	
	<u> </u>	l	15	€20-	-MS20470AD4-7_	I-KIVET

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Revision: \boldsymbol{D}

Date: 08.07.08

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